



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.7210

Job Sheet 211857



Part No: 650.7210

Job Qty: 5 pcs

Part Name: Bayonet Body



139 Valve

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/20

Job Tracking No:

Due Date: 8/7/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG 650.7200 REV.PA2 IPP REV A 20.06.22 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	5 pcs	8/7/20	8/7/20	1.00	1.67	SL-154 - 1		JB 20.08.10
110	QC 2	5 pcs	8/7/20	8/7/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 20.08.10
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S293178



Part: 650.7210

Job No: 211857

Serial No/Batch: S293178

Revision: REV.PA2

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/10/20

Plex 7/30/20 7:17 AM Dart.Renwick.Jennifer

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SVIOL PΣ!

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	5 pcs	8/7/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
160	Packaging 3-1 - Stock - B4B	5 pcs	8/7/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B

7/20/08/20

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AUG 21 2020

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170	QC 21 - SA	5 pcs	8/7/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
Part Op 100 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD316 FOLIO REV: Descriptions: <u>AA</u> DWG REV: <u>PA2</u> 2-Debur 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 160 - Identify as per dwg & Stock 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R0.625	303 Round Bar 0.625"	.3125 ft (.0625 ea)	100-SL-154 - 1	5250214	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-154 - 1	M303R0.625	0	11	0	
Part Specifications					
Specifications could not be found.					

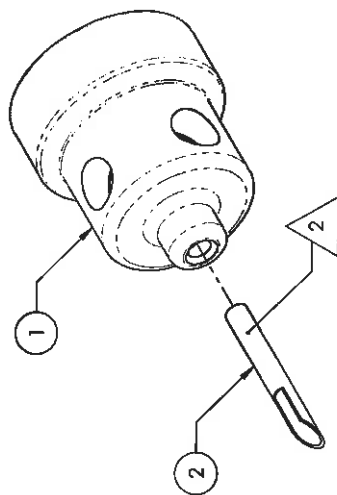
Plex 7/30/20 7:17 AM Dart.Renwick.Jennifer

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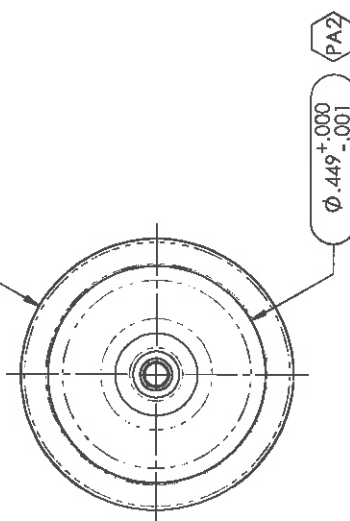
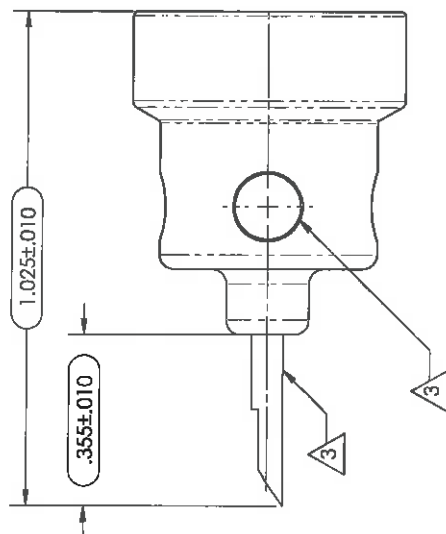
NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY ITW DEVCON 14200 SERIES EPOXY (OR SIMILAR) TO MATING SURFACES OF BAYONET F/N 2 AND BAYONET BODY F/N 1
3. ROTATIONAL ALIGNMENT OF BAYONET F/N 2 AND BAYONET BODY F/N 1 IS ARBITRARY; ACTUAL POSITION MAY VARY
4. UNLESS OTHERWISE NOTED DEBURR AND BREAK ALL SHARP EDGES
5. SHARPEN BAYONET TIP FOLLOWING ELLIPTICAL EDGE
6. MATERIAL: 303 SS IAW AMS-5640 **(23)**
7. MATERIAL: 303 SS IAW AMS-5640 OR 304 SS IAW ASTM A908
8. FINISH $\sqrt{125}$ MAXIMUM UNLESS OTHERWISE SPECIFIED **(29)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 211857



650.7201



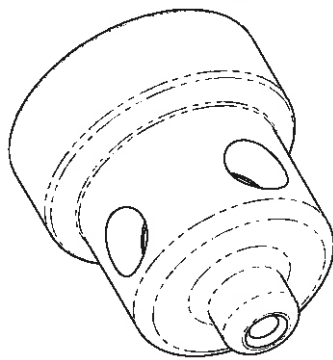
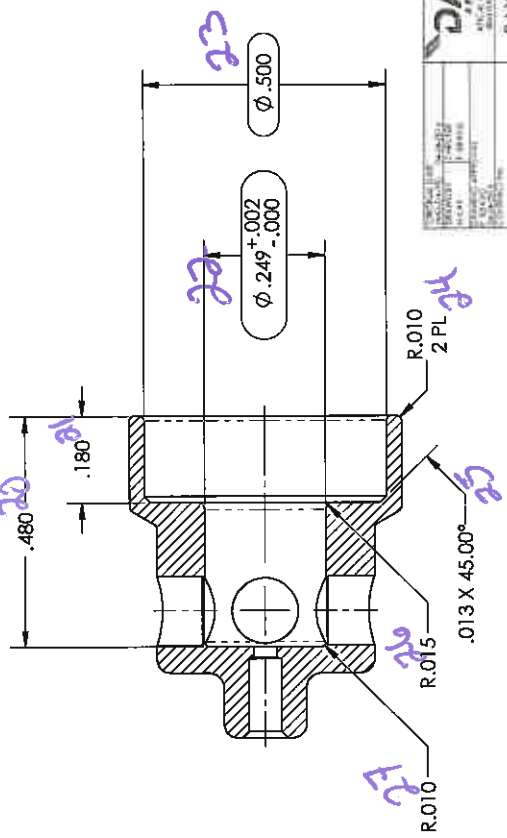
PROTOTYPE REVISIONS			
ZONE	REV	DESCRIPTION	DATE
B1-1		ADDED NOTE FOR 304 MATERIAL. RENUMBERED NOTES AS REQUIRED	
B2-1		DIMENSION WAS Ø.562±.001 IS Ø.562±.000/-0.002	
B7-1		DIMENSION WAS 449.5701 IS 460.7201	
A3-2		DIMENSION WAS Ø.449±.001 IS Ø.449±.000/-0.002	
A4-2		DIMENSION WAS Ø.562±.001 IS Ø.562±.000/-0.002	
B3-2		DIMENSION WAS Ø.449±.001 IS Ø.449±.000/-0.002	
C3-2		DIMENSION WAS .495 IS .480	
D2-2		DIMENSION WAS .320±.010 IS .32	
D3-1		DIMENSION WAS Ø.562±.000/-0.002 IS Ø.562±.000/-0.001	
A3-2		DIMENSION WAS Ø.449±.000/-0.002 IS Ø.449±.000/-0.001	
B3-2		DIMENSION WAS Ø.562±.000/-0.002 IS Ø.562±.000/-0.001	

1	2	650.7201	BAYONET	3030 ENTERPRISE CT.
			BAYONET BODY	SUITE A
			BAYONET ASSEMBLY	VIEW 1
				APPROVAL
				DATE
				CONTRACT NO.
				INTEL. OPER. PROC.
				QUANTITY
				SCALE
				SHEET

PART

BAYONET ASSEMBLY

SCALE NONE

650.7210 Δ 7

SECTION B-B

[illegible]

Description: BAYONET ASSEMBLY – BODY

Part Number:

650.7210

Inspection Dwg: 650.7200

Rev: PA2

Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	Ø .067	+ .004 / - .001	.066	✓		GP .066 / .072 (Ref)	
2	.165 DEEP	± .005	.165 ^s	✓		Vernier + GP JB-01	
3	Ø .095 X 90.0°	± .005 X .5°	.096 ^s x 90°	✓		Vernier - JB-01	
4	Ø .562	+ .000 / - .001	.561 ⁷	✓		Mic	JB-09
5	Ø .047	± .005	.047	✓		Wire .045 (Ref)	
6	Ø .449	+ .000 / - .001	.448 ⁷	✓		mic	JB-09
7	R .030	± .005	R .030	✓		RG 1/32 (Ref)	
8	R .008	± .005	R .008	✓		insert Rod (Ref)	
9	R .015	± .005	R .015 ⁶	✓		RG 1/64 (Ref)	
10	60.0°	± .5°	60°	✓		Optical comp.	
11	.670	± .005	.672	✓		Vernier	JB-01
12	.475	± .003	.475 ⁶	✓		optical comp	
13	.265	± .003	.265 ⁹	✓		optical comp	
14	.135	± .005	.135 ²	✓		Optical comp.	
15	Ø .170	± .005	.171 ³	✓		mic	JB-09
16	.095	± .003	.095 ⁵	✓		vernier + GP JB-01	
17	Ø .145	+ .005 / - .000	.147	✓		GP 1/16 / .151 (Ref)	
18	Ø .136	+ .000 / - .005	.134	✓		GP 1/16 / .132 (Ref)	
19	90.00°	± .5°	90°	✓		optical comp.	
20	.480	± .005	.480	✓		Vernier	JB-01
21	.180	± .005	.179 ⁵	✓		Vernier	JB-01
22	Ø .249	+ .002 / - .000	.250	✓		inside mic	LP-04
23	Ø .500	± .005	.500 ²	✓		inside mic	LP-04
24	R .010	± .005	R .010	✓		RG 1/64 (Ref)	
25	.013 X 45.00°	± .005 X .5°	.013 x 45°	✓		vernier	JB-01
26	R .015	± .005	R .015	✓		RG 1/64 (Ref)	
27	R .010	± .005	R .010	✓		RG 1/64 (Ref)	
28	303SS AMS S640		303SS AMS S640	✓		MILL TEST AT TURNED	
29	✓125	DAS 62 9-89	✓125	✓		H/K 462762 MICRO FINISH comp.	

Measured by:

JB

Checked by:

mg

QC Inspector:

Date:

20-08-10

Date:

20/08/20

Date:

Engineering Approval:
(If necessary)

Date:

Rev

Date

Change

Revised by

Approved

A

8-Aug-20

New Issue

MG

Larralde SGIU (VIZCAYA) España
P.O. Box 1.323/48080 Bilbao
Tel. 34-(94) 4 71 13 00
Fax.34-(94) 4 53 16 16

Plasmagmat systems
Certified by
LQQA
ISO 9001 / 801 6000390
ISO 14001 / 801 6070870

ACEROS INOXIDABLES

OLARRA

Trade Mark - Zeichen des Lieferwerkes
Anagrama del suministrador

Works Inspector Stamp - Werkssachverständiger
Sello del Inspector



Certificate type - APZ Nach
Certificado tipo EN 10204/3.1 Certificate n° - Prüf-Nr
Certificado n° 382910 Date - Datum - Fecha
13-09-2018

Our order N°
Works - Nr
N° de Referencia 665995 Heat
Schmelze
Código 462762 Your order N°
Bestell - Nr
Pedido N° C113864

Steel Grade
Werkstoff
Calidad AISI-303 According to
Entsprechend
Corresponde ASTM A 582 / A 582M-12. 82
9-86

Shape and Size - Gegenstand
Perfil y dimensión
ROUND 5/8" Tolerance - Toleranz
Tolerancia ASTM A 484 / TB.7 Bundles
Bünde 1 Bars
Stäbe
Barras Weight
Gewicht
Peso 1673 Lbs

Requirements - Anforderungen - Exigencias

QQ-S 764B-70 AMD2 COND A.
SAE AISI 5640U-07. TYPE I.
EN 10-088-3-2014.
1.4305.
MECAMAX - PLUS

Melting process / Erhmelzungsart / Proceso de Fusión
E.A.F. / A.O.D.

Heat treatment / Wärmebehandlung / Tratamiento térmico
1050C 4H/Std WATER/WASSER/AGUA

Solution annealed/Abgeschreckt/Hilportompla-Cold drawn/Gezogen/Soltrido-Polished/Poliert/Pulido-

Test results - Ergebnis der Prüfungen - Resultados de los ensayos

Dimension of Specimen Abmessungen des Probastabes Medida de las probetas	Rp0.2% KSI	Rp 1% KSI	Rm KSI	A %L 6D	A %L 4D	Z %	Hardness Härte HBw	Impact test / Kerbschlag / Resiliencia ISO V ft. lb
RD. 12,50 mm.	Min.							
	Max.						262	
Temperature °C 20	Spec. N° Probe Nr. Pro N°	1	84	94	105	33	55	217

	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	N	Co
Min.					0,150	17,00		8,00			
Max.	0,150	1,00	2,00	0,200		19,00		10,00	0,70	0,1000	
	0,048	0,48	1,83	0,038	0,334	17,73	0,40	8,41	0,48	0,03-00	0,18

Visual and dimensional inspection
Besichtigung und Ausmessung O.K.
Control visual y dimensional Radiactivity inspection
Radioaktivitätskontrolle O.K.
Control de Radioactividad Antirinding test
Spaltrost Verwachsungspr O.K.
Antirresaca Grain Size
Korngröße
Tamaño de grano

Remarks - Bemerkungen - Observaciones

Free From Mercury contamination/Quecksilberfreiheit.
No weld repair.

EDV / EDP
Acc. EN 10.204
Marian Tejedo
Quality Mng.

Works Inspector
Der Werkssachverständige
Inspector de fábrica

We hereby certify that material described herein complies with the requirements agreed on the order.

Firmado digitalmente por / Signed digitally by:
ACEROS INOXIDABLES OLARRA SA - CIF A46063646
Fecha / Date: 13-09-2018 10:32

221596

[illegible]

L10E4

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M303R 0.625
 DATE: JAN 24 2020

PO / BATCH NO.: POH304554/
S250214

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 25 FT
 QUANTITY INSPECTED: 25 FT
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.625
 THICKNESS RECEIVED: 0.625
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	☒ Y ☐ N	<u>605 2-20/01/24</u>
CORRECT FINISH	☒ Y ☐ N	
CORROSION	☒ Y ☐ N	
CORRECT GRAIN DIRECTION	☒ Y ☐ N	<u>ASTM A582</u>
CORRECT MATERIAL PER M-DRAWING	☒ Y ☐ N	
CORRECT THICKNESS	☒ Y ☐ N	
PHOTO REQUIRED	☒ Y ☐ N	<u>462762</u>
CORRECT REF # TO LINK CERT	☒ Y ☐ N	
CORRECT MATERIAL IDENTIFICATION	☒ Y ☐ N	
CORRECT M# ON THE MATERIAL	☒ Y ☐ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	☒ Y ☐ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	☒ Y ☐ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: _____	DAC <u>82</u>	SIGNED OFF BY: _____	
DATE: <u>JAN 24 2020</u>	9-89	DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

LINE 4
M303R0.625

HT 4622762
S250214

SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 303 SS ROUND BAR
(NOTE: AISI 304/316 NOT ACCEPTABLE)

SPECIFICATION: ASTM A564

PART NUMBER: M303RD.D00
DIA.

WHERE "D.D00" = DIAMETER IN INCHES
EG. 0.75" ROUND BAR = M303RD.750

DAS
82
9.89

RELEASED
2010-02-02
MD

B		REFORMAT DWG. ADD SPECS (21 DA-11)		CP	10.01.06
A		NEW ISSUE		DS	01.12.20
REV.	DESCRIPTION	BY	DATE		
DESIGN				DART AEROSPACE LTD	
DRAWN				HAWKESBURY, ONTARIO, CANADA	
CHECKED				REV. B	
MFG. APPR.				DRAWING NO. M303R	
APPROVED				SHEET 1 OF 1	
DE APPR.				SCALE	
DATE	10.01.05			MFG.	
				303 ROUND BAR	
				DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
				SHEET 1 OF 1	
				SCALE	
				MFG.	

